

Work Order ID 69534

Wednesday, May 11, 2011 4:06:30 PM



Page 1

Item ID:	D2673-34	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	End Plate					
Start Date:	5/11/2011	Start Qty:	60.00		Cust Item ID:	
Required Date:	5/16/2011	Req'd Qty:	60.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-05-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2673	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2673 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-								
606' . G80	Deburr if necessary								

11-5-17

76

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

11-5-17

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

8 11/05/18

76

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69534

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Item ID: D2673-34

Accept



Setup Start



Revision ID:

Stop



Item Name: End Plate

Start Date: 5/11/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		<u>11-05-18</u>		<u>76</u>	<u>0</u>		
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/5/18</u>

11-05-18

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 69534

Parent Item: D2673-34

Parent Item Name: End Plate





Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP C02.01.14 Removed deburr and inspect level 5 NG/EC
IPP Rev:D Now 6061-T6 06-06-23 JLM
IPP Rev:C Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080  6061-T6 .080 Sheet		Purchased	No			100	sf	334.5000	0.052	3.284211			
										117285			
										117285			
										117285			

B11-5-17

76

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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED 	DRAWING NO. D2673	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE END PLATE	SCALE 1:1
A	97.05.06	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

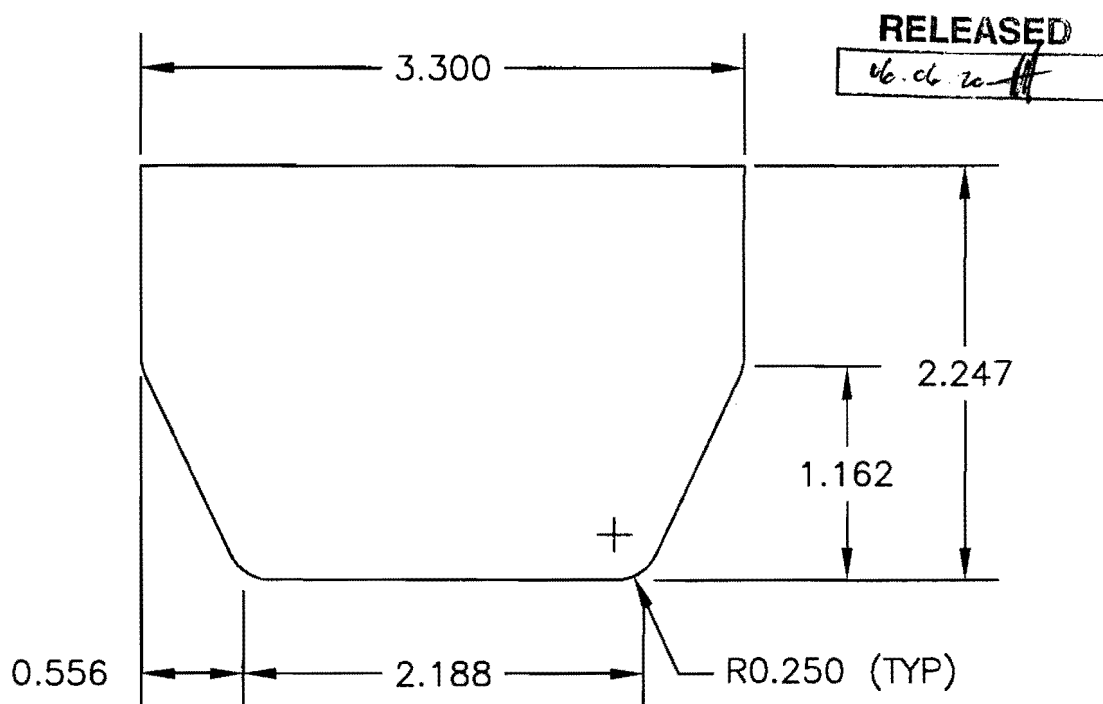
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 49534

END PLATE FOR D2244 EXTRUSION CUT AT 34°

PH/11-05-12



D2673-34

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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